

Date: Monday, 3/13/2006 7:29:48 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: 3" SKID EXTRUSION (NO OUTER RIDGE)	
Job Number	: 26205		Part Number	: D26003120	
Estimate Number	: 10054		Drawing Number	: D2600 REV D1	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 3/13/2006	S.O. No. : N/A	Drawing Revision	: D1	
Prsht Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 4/5/2006	
Previous Run	: 23201		Qty:	78	Um: Each
Written By	: <u>See COMMENT Below</u>				
Checked & Approved By	: <u>106.03.13</u>				
Comment	: Est. D: 02.09.10 Added DSK 066 KJ/RF				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PG	PURCHASING
Comment: PURCHASING Issue P/O: <u>00000825</u> <i>Al de 103/20</i> a) Extrude as per Dwg D2600 b) Material: 6061-T6 (QQ-A-200/8) c) Minimum yield tensile strength = 35 ksi d) Minimum ultimate tensile strength = 40 ksi e) Minimum elongation = 8% f) Order at 120" long g) Bon L Canada Inc. tool # 897122 h) To be packed per DSK 066 i) Pull test to ASTM standard B221 required. j) Material certification is required		
2.0	D26003120P	Extrusion Round 3" 350
Comment: Qty.: 1.0000 Each(s)/Unit Total : 140.0000 Each(s) Extrusion Round 3" 350		
3.0	PACKAGING 1	PACKAGING RESOURCE #1
Comment: PACKAGING RESOURCE #1 Receive & Inspect For Transit Damage Ensure material certification is attached		
4.0	QC6	DIMENSIONAL CHECK
Comment: DIMENSIONAL CHECK Inspect dimension per Dwg D2600 Check Pull test per Dwg D2600 for compliance page attached Check hardness with Webster tester		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/01/05
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 3/13/2006 7:29:49 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 3" SKID EXTRUSION (NO OUTER RIDGE)

Job Number: 26205

Part Number: D26003120

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: LG

78
26-04-04

6.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

78
26-04-05

Job Completion



26-04-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>DKY</i>	DRAWN BY <i>DKY</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>AS</i>	DRAWING NO. D2600	REV. D SHEET 1 OF 5
DATE 98.08.20		TITLE EXTRUSION	SCALE 1:1
A	97.01.21	NEW ISSUE	
B	97.09.09	CHANGE MATERIAL SPEC.	
C	98.04.16	ADD D2600-3, UPDATE D2600-1 WIDTH, ADD DIE NO.	
D	98.08.20	INCREASE MIN. UTS TO 40 KSI	
D1	01.04.17	ADD PART NUMBERS & DIE NUMBERS <i>+ GP</i>	

RELEASED
 48.08.25 DS

GENERAL NOTES

1. MATERIAL: 6061-T6 (QQ-A-200/8)

MINIMUM YIELD TENSILE STRENGTH = 35 ksi
 MINIMUM ULTIMATE TENSILE STRENGTH = 40 ksi
 MINIMUM ELONGATION = 8 %

A SAMPLE FROM EACH BATCH WILL BE PULL TESTED
 TO ASTM STANDARD B221 BY AN APPROVED TESTING
 FACILITY TO ENSURE THAT THE BATCH MEETS THE
 ABOVE MINIMUM MECHANICAL PROPERTIES.

2. BREAK ALL SHARP CORNERS 0.010 MAX.

3. NO TOOLING MARKS.

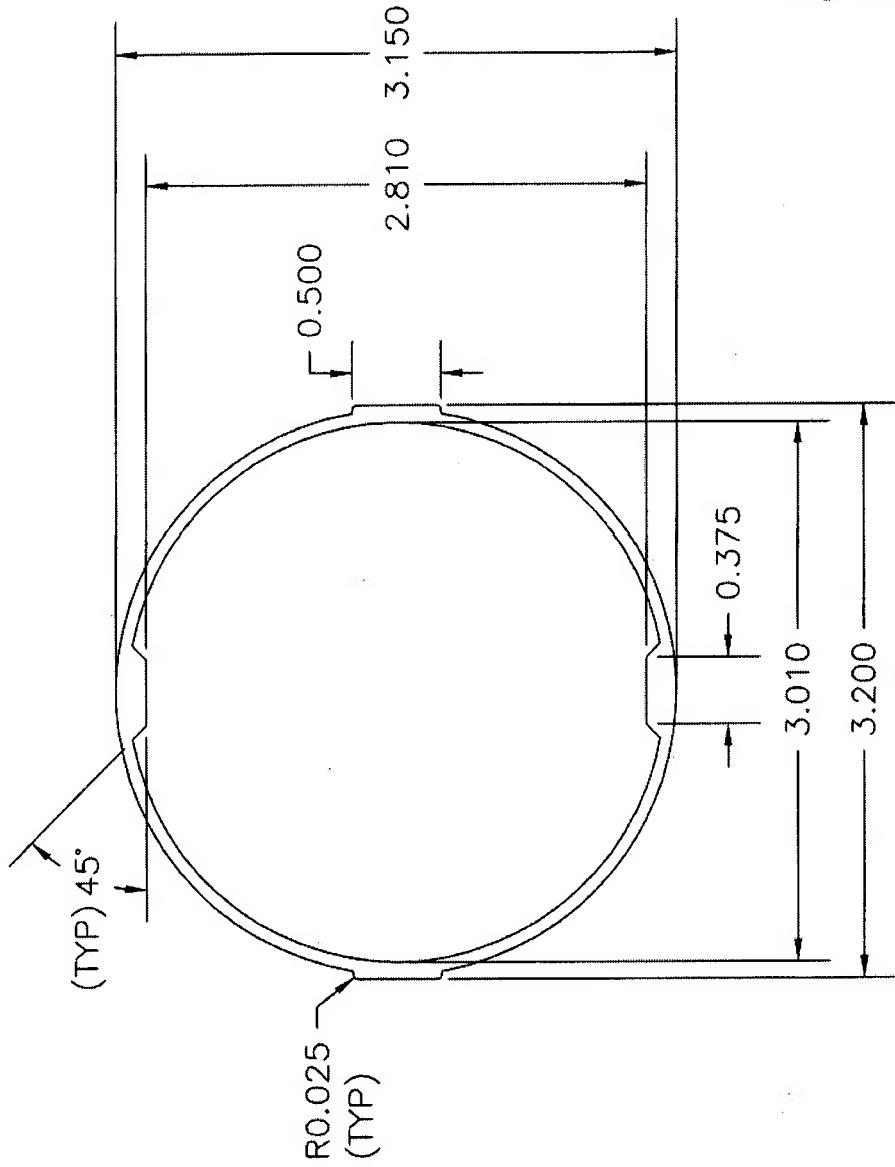
4. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE
 NOTED.

5. ALL DIMENSIONS ARE IN INCHES.

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DATE	98.08.20	TITLE	SCALE 1:1

D2600-1

MANUFACTURED WITH CARADON INDALEX DIE # MH-18870
OR BON L DIE # 897121 (PREFERRED CHOICE)
PART NUMBER IS D2600-1-XXX WHERE XXX IS CUT LENGTH IN INCHES (EG. D2600-1-160 IS 160 1/16" LONG)

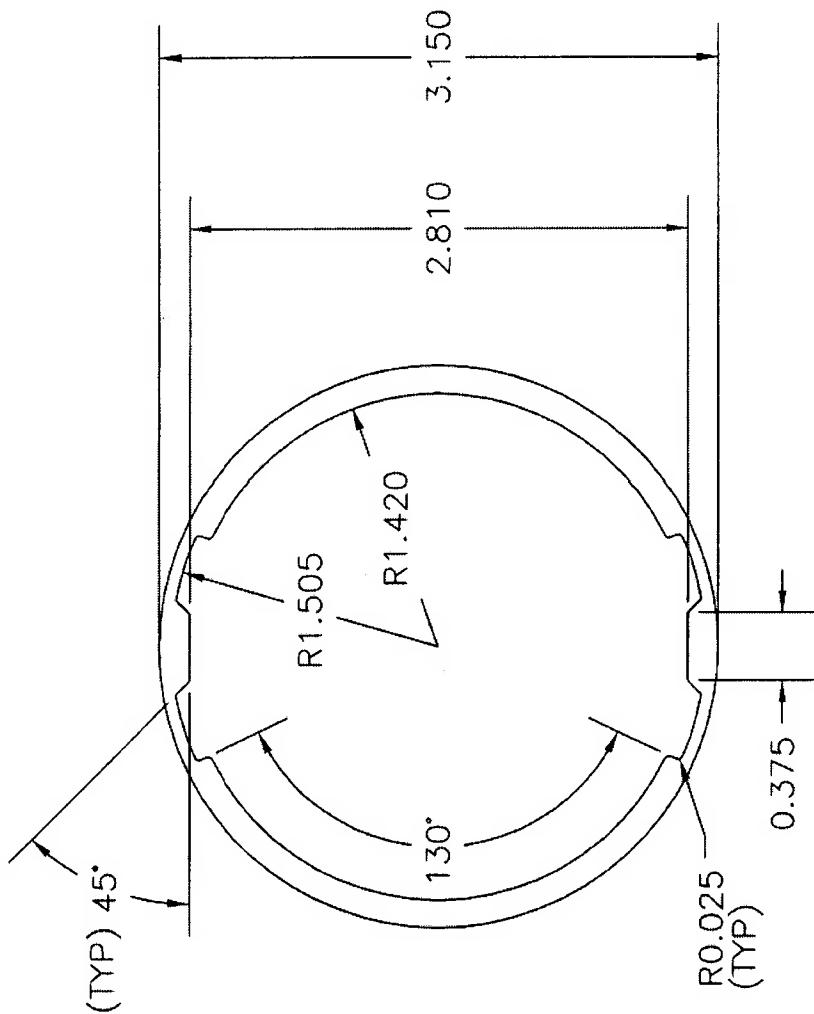


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KE	CH	D2600	SHEET 3 OF 5
DATE		TITLE	SCALE
98.08.20		EXTRUSION	1:1

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98.8.25 DS

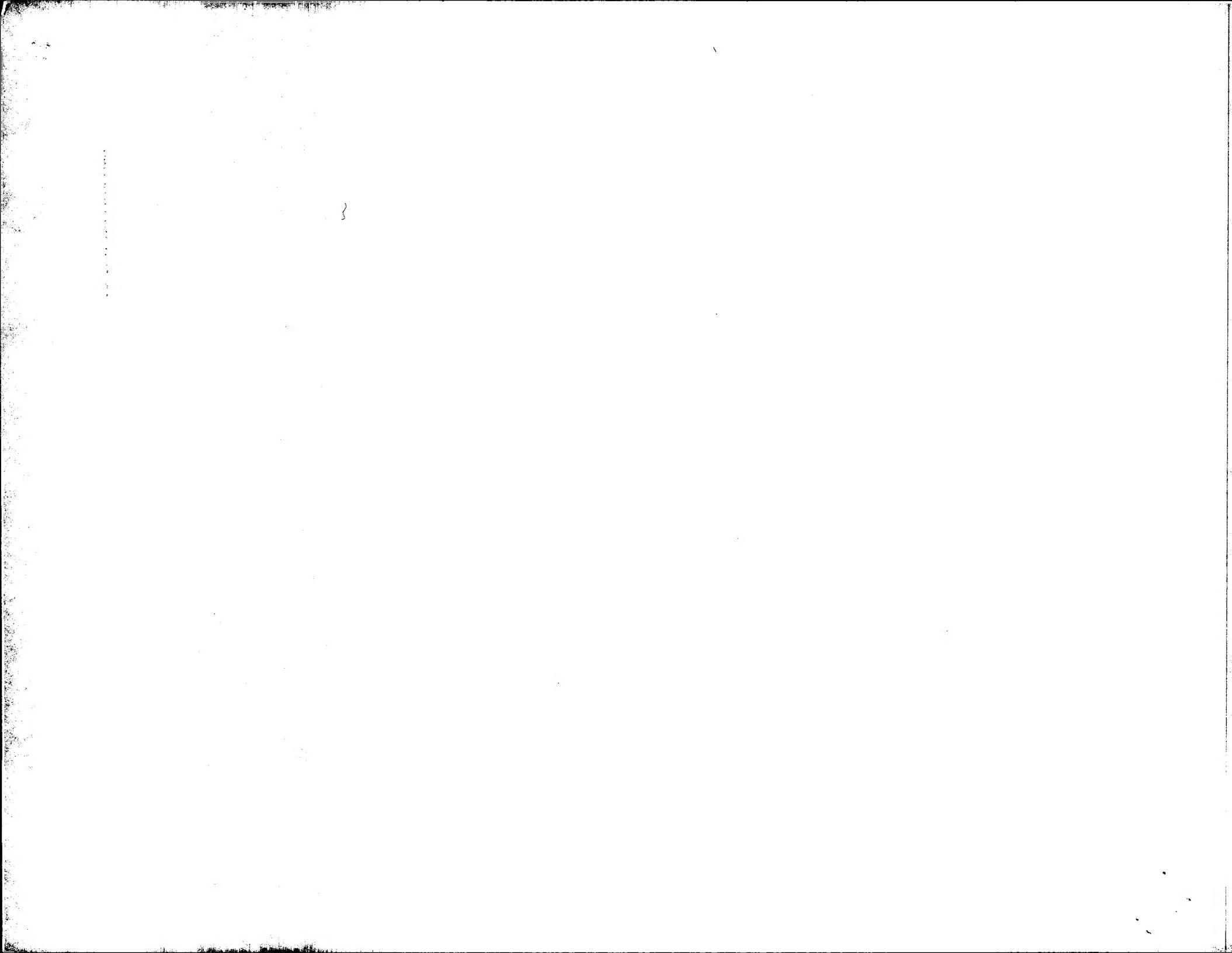
D2600-3

MANUFACTURED WITH CARADON INDALEX DIE # MH-18859
OR BON L DIE # 897122 (PREFERRED CHOICE)
PART NUMBER IS D2600-3-XXX WHERE XXX IS CUT LENGTH IN INCHES (EE. D2600-3-120 IS 120" LONG)



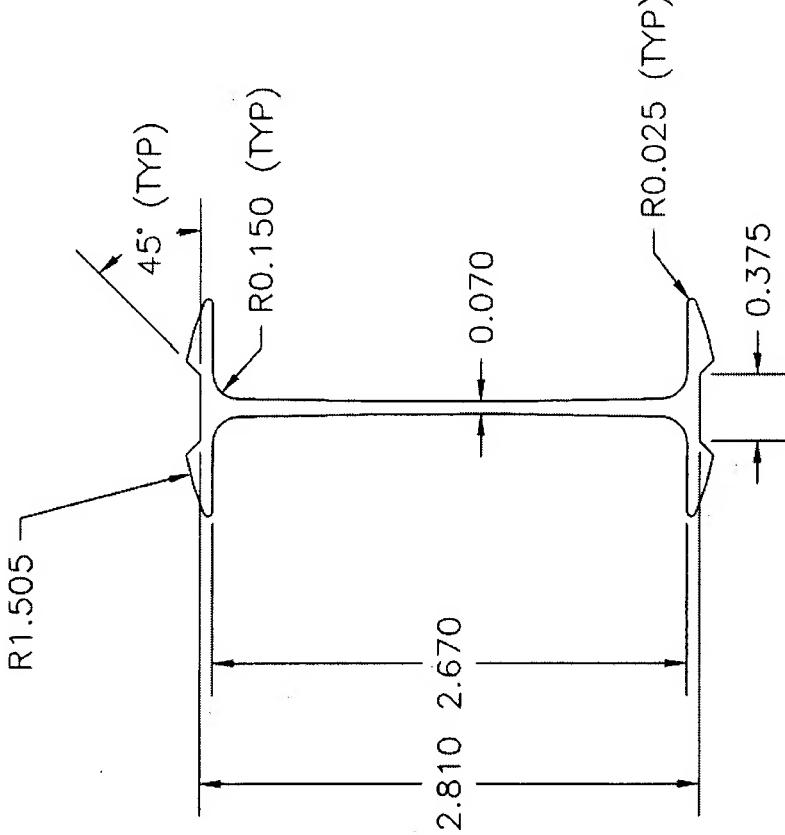
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NO. 26205



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CHECKED <i>KE</i>	APPROVED <i>JK</i>	DRAWING NO. D2600	REV. D SHEET 4 OF 5
DATE 98.08.20		TITLE EXTRUSION	SCALE 1:1

RELEASED
98.8.25. DSD2600-5

MANUFACTURED WITH CARADON INDALEX DIE # MS-18871
PART NUMBER IS D2600-5-XXX WHERE XXX IS CUT LENGTH IN INCHES
(E.G. D2600-5-108 IS 108" LONG)

D1

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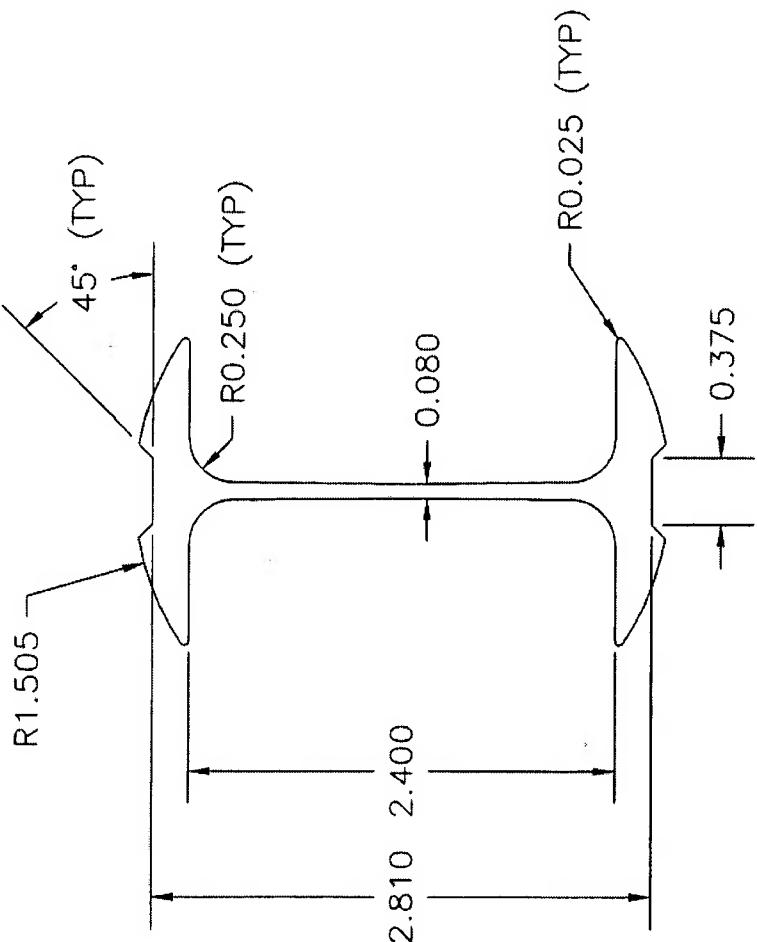
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NO. 26205

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DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2600
DATE		REV. 0 SHEET 5 OF 5 SCALE 1:1

RELEASED
98.8.25 DS

D2600-7

MANUFACTURED WITH CARADON INDALEX DIE # MS-18872
PART NUMBER IS D2600-7-XXX WHERE XXX IS CURT LENGTH IN INCHES
(EG. D2600-7-125 IS 125" LONG)

D1

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CERTIFICATE OF COMPLIANCE

BON L CANADA INC

1850 CLEMENTS ROAD
PICKERING, ON L1W 3R8

Cart. Date	Cart. No.	Sales Order	Page
04/02/06	137149	14055	1
Cust. PO	Part No.	For	Date
825	00299028	14055010	4/02/06

Part No	Ship. To	Ship. No	
DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7		DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7	
Item No	Part No	Item Description	Cust Part
1.000	DAA-897122-1	120" Mill 6061 T6	D2600-3-120
Gross Weight	566 KGS		
Net Wt.	558 KG	78 PC	238 M
Specifcation	AMS-QQ-A-200/8 & ASTM B221-00		Die Desc

Mechanical Tests:

Test No.	Tensile MPA / KSI	Yield MPA / KSI	%Elongation	Conductivity	Bend/Drift HREW
1	311.0 / 45.1	291.8 / 42.3	11.3	.0	93

Chemical Limits:

SI	FE	CU	MN	MG	CR	ZN	TI	OTHER
MIN:	.40	.00	.15	.00	.80	.04	.00	EA: .05
MAX:	.80	.70	.40	.15	1.20	.35	.25	.15 TOT: .15

This will certify that the material described herein has been inspected and tested in accordance with Bon L Canada's standard sampling and testing procedures or in accordance with the requirements of any specifications forming a part of the material description to the extent indicated herein. Data of chemical composition for the material and test results from samples representative of the material are set forth above hereof or in any attachments hereto. This information shows that the material meets the applicable requirements. Inspection and test records are maintained on file. This certificate shall be deemed apart of and subject to the terms and conditions of warranty set forth on the reverse side of our order acknowledgement form. No other warranties are applicable.

Conchita Ko, QA Manager Signed for Bon L Canada

PJ 825